

Work Order ID 70331

Thursday, June 02, 2011 3:36:08 PM

Page 1

Item ID: D350-607-041A Accept

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011 Start Qty: 1.00

Required Date: 6/20/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: CL Date: 11/06/03 Tooling:

QC: _____ Date: _____ SPC (Y/N): _____

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100	DOCUMENT CONTROL	0.00
DC	Memo	0.00
Document Control	Photocopy bluefile & type labels per PPPD350-607-041A CHG001	

110	Pick Kit	0.00
-----	----------	------

Packaging	Memo	0.00
Packaging		

120	Small Fab	0.00
-----	-----------	------

Small Fab	Memo	0.00
Small Fab	Assemble as per Dwg D350-607 / DSI 9473	
	Seal support gusset seam with white sikaflex-291	
	Batch: <u>M116945</u>	
	Expiry date: <u>15/01/12</u>	

CL 11-6-14

11/6/13

11/06/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*****Ensure label for weight capacity is correct*****

Sublet

ⓧ

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/13

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sublet

W/O:		WORK ORDER CHANGES						
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Page 3

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Start Date: 6/2/2011 Start Qty: 1.00

Required Date: 6/20/2011 Req'd Qty: 1.00

Reference:



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-041A
Location: _____

170

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, June 02, 2011 3:35:59 PM

Page 1

Work Order ID: 70331

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)




Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.01.18 verified by:EC
545 DD 10.04.19 verified by:EC
607-141 and added individual parts of D350-607-141 in DD verf:JLM
IPP RevB: as
IPP Rev:C as per ecn10-
IPP Rev:D 10.10.18 remove D350-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			110	Each	42.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST324			42						
				117795			22			4			
				117872			20						
AN3C11A  BOLT		Purchased	No			110	Each	24.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351			24			4			
				116590			24			4			
AN3C16A  Bolt		Purchased	No			110	Each	39.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST352			39			4			
				115835			39			4			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, June 02, 2011 3:36:00 PM

Page 2

Work Order ID: 70331

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-1

 Gas Spring Bracket

Manufactured No

110 Each 29.0000

2

2



SL

Location

Loc Qty

Loc Code

ST096

29

52756

1

53760

28

1

1

D3953-11

 Gas Spring Spacer

Manufactured No

110 Each 11.0000

2

2



SL

Location

Loc Qty

Loc Code

ST096

11

68232

11

2

2

D3953-13

 Gas Spring Spacer

Manufactured No

110 Each 26.0000

2

2



SL

Location

Loc Qty

Loc Code

ST096

26

52761

26

2

2

D3953-3

 Gas Spring Stud, Lid

Manufactured No

110 Each 13.0000

2

2



SL

Location

Loc Qty

Loc Code

ST096

13

69611

13

2

2

D3953-5

 Gas Spring Stud, Base

Manufactured No

110 Each 17.0000

2

2



11/6/11 388

Location

Loc Qty

Loc Code

ST096

17

69749

17

8

Thursday, June 02, 2011 3:36:00 PM

Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, June 02, 2011 3:36:00 PM

Page 3

Work Order ID: 70331

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-7
Spring Spacer
Manufactured No

110 Each 10.0000



2
2

Location

Loc Qty

Loc Code

ST096

10

65053

4

68464

6

D3953-9
Gas Spring Washer
Manufactured No

110 Each 65.0000



4
4

Location

Loc Qty

Loc Code

ST096

65

69025

5

69973

60

D3969-1
Spring (Basket Lid)
Manufactured No

110 Each 9.0000



2
2

Location

Loc Qty

Loc Code

ST272

9

52889

9

MS21043-3
Nut
Purchased No

110 Each 449.0000



8
8
11/6/13

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

369

112314

369

Thursday, June 02, 2011 3:36:00 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Thursday, June 02, 2011 3:36:00 PM

Page 4

Work Order ID: 70331



Parent Item: D350-607-041A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-2-12 Purchased No



COTTER PIN

110 Each 30.0000 4



[Handwritten signature]

Location

Loc Qty

Loc Code

ST309

30

111499

30

NAS1149C0332R Purchased No



Washer

110 Each 2,982.000 8



[Handwritten signature]

Location

Loc Qty

Loc Code

ST297

2982

116304

55

117291

1327

117460

600

117887

1000

NAS1149C0432R Purchased No



Washer

110 Each 5,884.000 4



[Handwritten signature]

Location

Loc Qty

Loc Code

ST297

5884

116900

884

117291

5000

D350-607-241 Manufactured No



Basket Clamp Assembly

140 Each 4.0000 1



[Handwritten signature]

Location

Loc Qty

Loc Code

FG022

4

69365

1

69946

3

[Handwritten signature]

Thursday, June 02, 2011 3:36:00 PM

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Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Thursday, June 02, 2011 3:36:00 PM

Page 5

Work Order ID: 70331

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2022-101 Manufactured No 110 Each 19.0000 2 2
Spacer
B695325

Location	Loc Qty	Loc Code
ST504	19	
67768	19	

D2221 Manufactured No 110 Each 0.0000 1 1
350 Basket Base
D2258-200 Manufactured No 110 Each 11.0000 1 1
Placard 200lb
B 70358
E 5/6/14

Location	Loc Qty	Loc Code
ST505	11	
64284	1	
68928	10	

D2512 Manufactured No 110 Each 0.0000 1 1
Basket Lid 205/350
D2530 Manufactured No 110 Each 2.0000 1 1
Handle Weldment
B 70360
E 11/6/14
B69907 11/6/13

Location	Loc Qty	Loc Code
ST506	2	
68363	2	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Thursday, June 02, 2011 3:36:00 PM

Page 6

Work Order ID: 70331



Parent Item: D350-607-041A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2535 Manufactured No



Spring

110 Each 59.0000 2



2

Location

Loc Qty

Loc Code

ST504

59

~~66764~~

31

69495

28

2

D2537 Manufactured No



Bushing

110 Each 20.0000 2



2

Location

Loc Qty

Loc Code

ST504

20

66972

20

2

D2931 Manufactured No



Bumper

110 Each 660.0000 2



2

Location

Loc Qty

Loc Code

ST504

660

46064

660

2

AN3-16A Purchased No



Bolt

110 Each 139.0000 2



2

11/6/13

Location

Loc Qty

Loc Code

ST352

139

116419

39

117441

100

2

Thursday, June 02, 2011 3:36:00 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, June 02, 2011 3:36:00 PM

Page 7

Work Order ID: 70331

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-7A
Bolt

Purchased No

110 Each 267.0000 2



2

Location

Loc Qty

Loc Code

ST356

267

115373

17

117443

50

117514

200

AN5-17A
Bolt

Purchased No

110 Each 136.0000 4



4

Location

Loc Qty

Loc Code

ST339

136

116590

6

117313

30

117619

50

117872

50

MS20600-AD4W3
Cherry Rivets

Purchased No

110 Each 1,287.000 2



2

Location

Loc Qty

Loc Code

ST321

962

111636

262

117505

500

117601

200

WA018

325

107939

325

AN960JD416
Washer

NAS1149D0463J Purchased No

110 Each 0.0000 2



2

1117460 11/6/13

Thursday, June 02, 2011 3:36:01 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, June 02, 2011 3:36:01 PM

Page 8

Work Order ID: 70331

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased No



Washer

AN960JD8 NAS1149DN832J Purchased No



Washer

MS21042L3 Purchased No



Nut

110 Each 0.0000 4 4



M117309 1/2

110 Each 0.0000 2 2



M117316 1/2

110 Each 2,509.000 10 10



10

Location

ST300

116391
116540
116549
117441
117601
117885

Loc Qty

2509
11
36
762
800
400
500

Loc Code

10

MS21042L4 Purchased No



Nut

110 Each 5,711.000 2 2



116114 1/2

Location

ST300

116823
117441
117601
117885

Loc Qty

5711
411
3000
800
1500

Loc Code

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, June 02, 2011 3:36:01 PM

Page 9

Work Order ID: 70331



Parent Item: D350-607-041A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/2/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

1,172.000

4

4



11/6/14 SP

Nut

Location

ST300

116105

116548

117441

117591

117611

Loc Qty

1172

212

260

500

100

100

Loc Code

4

Thursday, June 02, 2011 3:36:01 PM

Shop Packet Print

Page 9

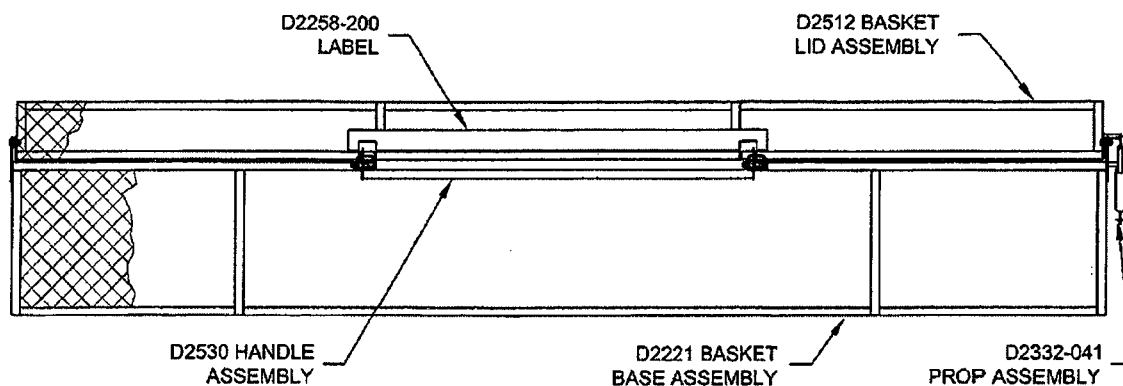
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

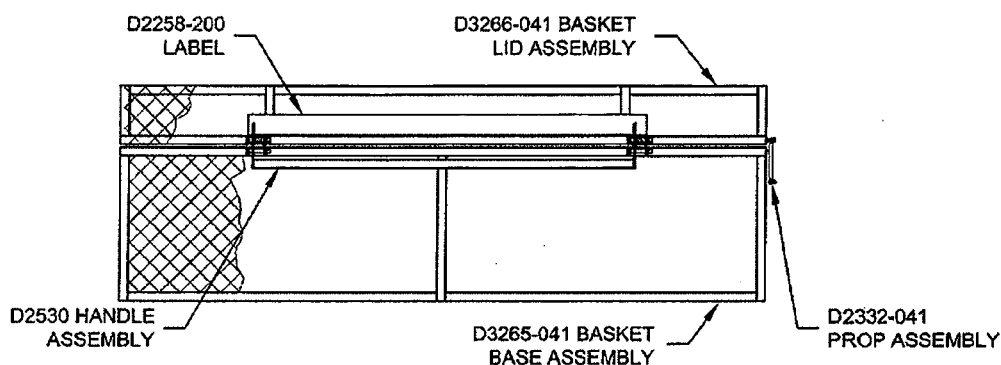
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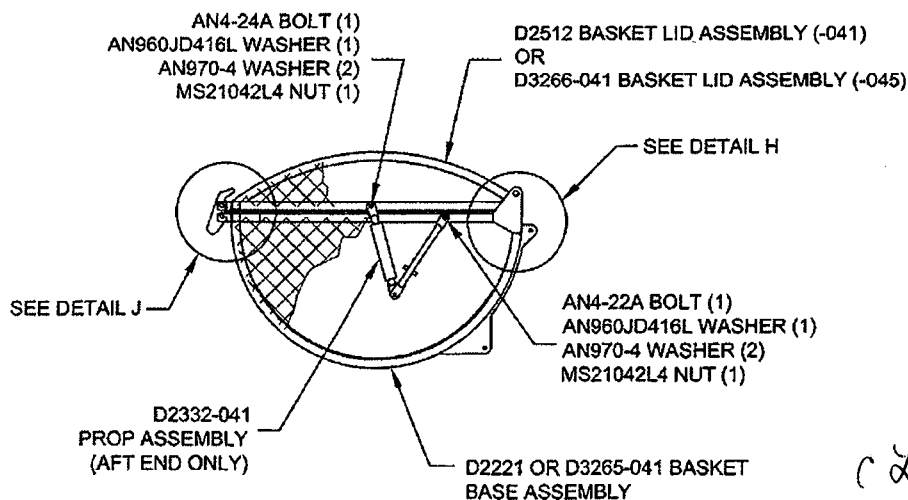
NOTE: Date & initial all entries



D350-607-041 HELI-UTILITY- BASKET™



D350-607-045 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

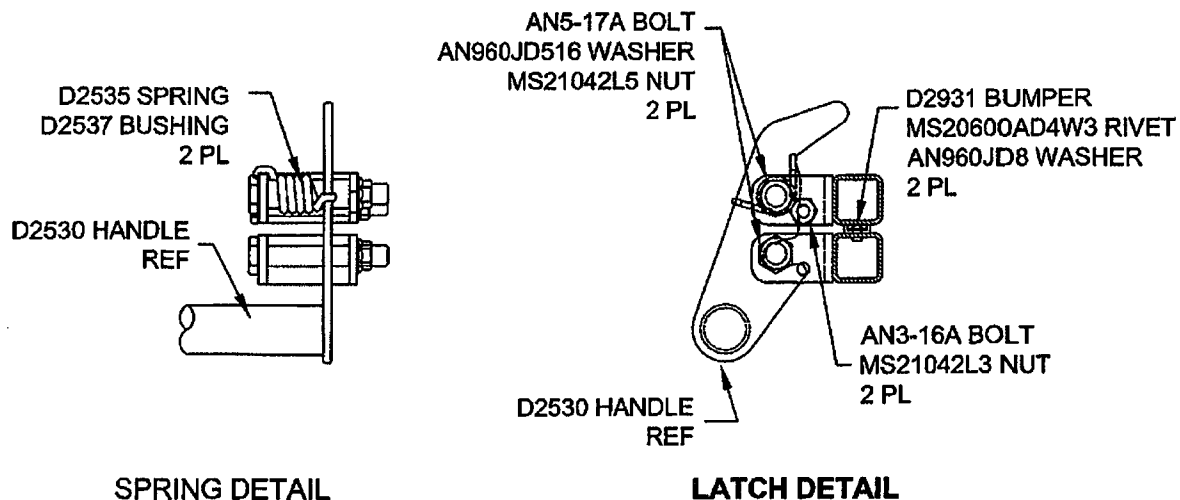
Figure 5 – Basket Replacement Parts

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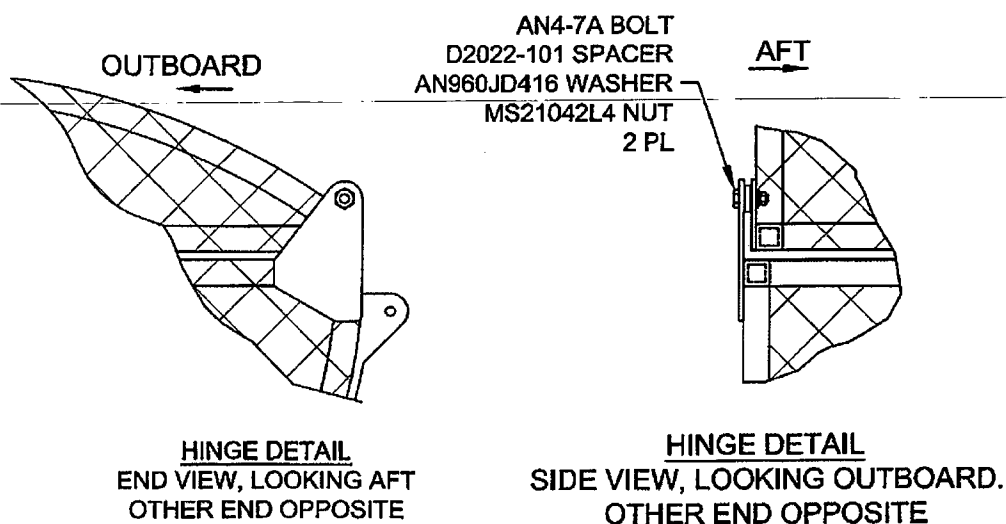
Revision: **A**
Date: 10.03.10

C/L 11/06/03
W/D. 70331





**DETAIL J:
HANDLE WELDMENT**



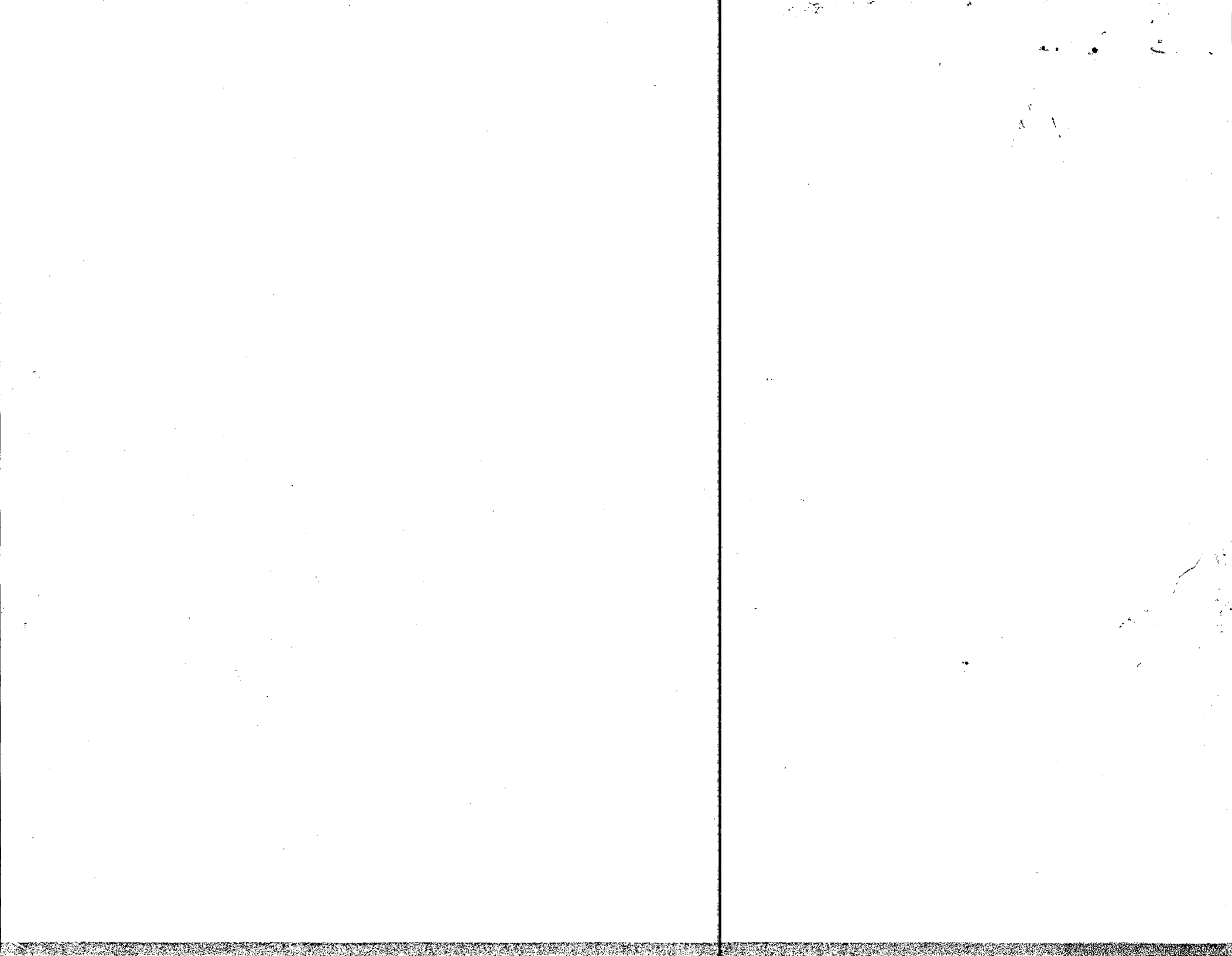
**DETAIL H:
HINGE**

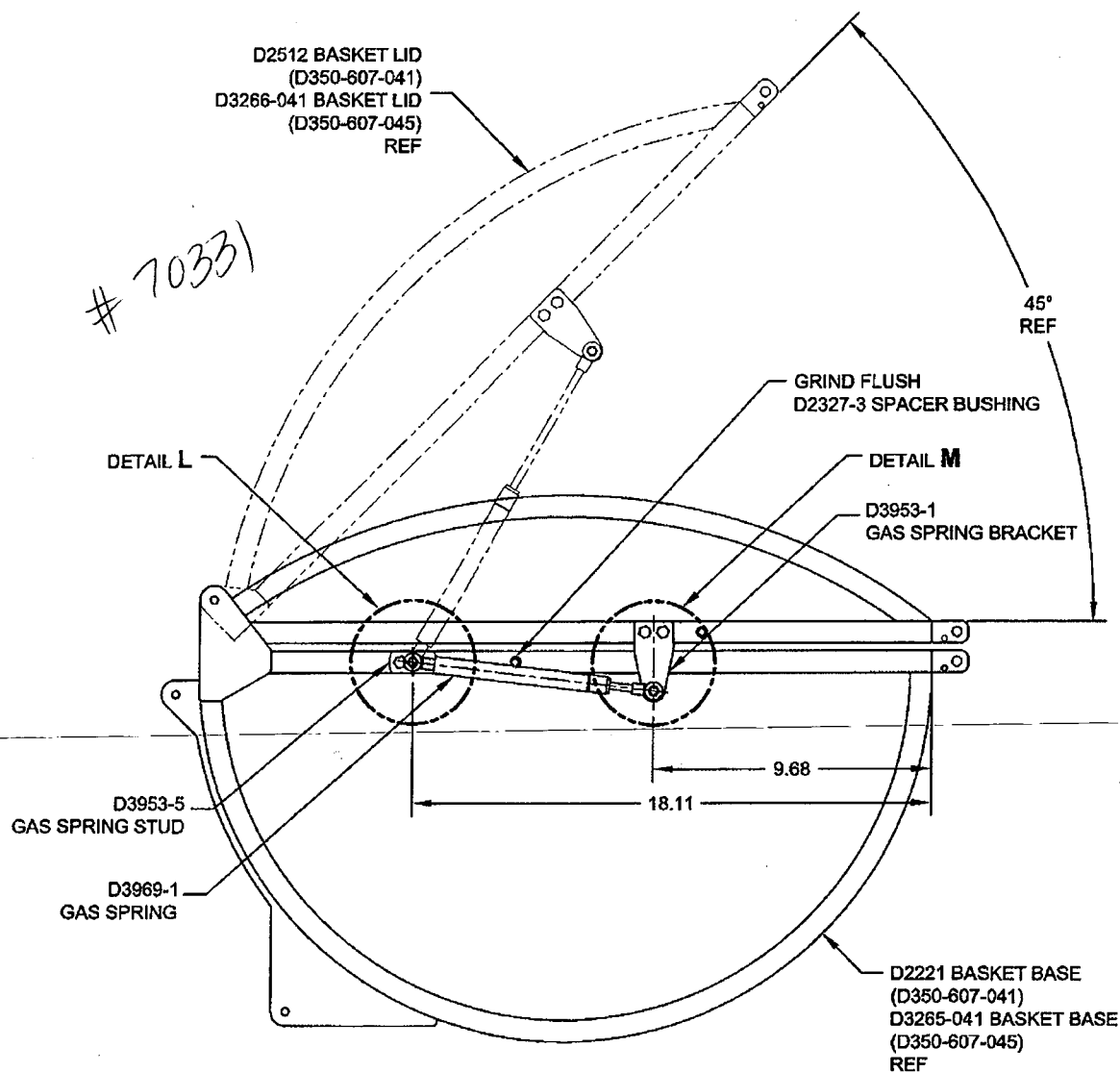
Figure 7 – Basket Replacement Parts

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Revision: **A**

Date: 10.03.10



**D350-607-141 AUTOMATIC LID OPENER INSTALLATION**

(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

Figure 8a – Automatic Lid Opener Installation

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Date: 10.03.10

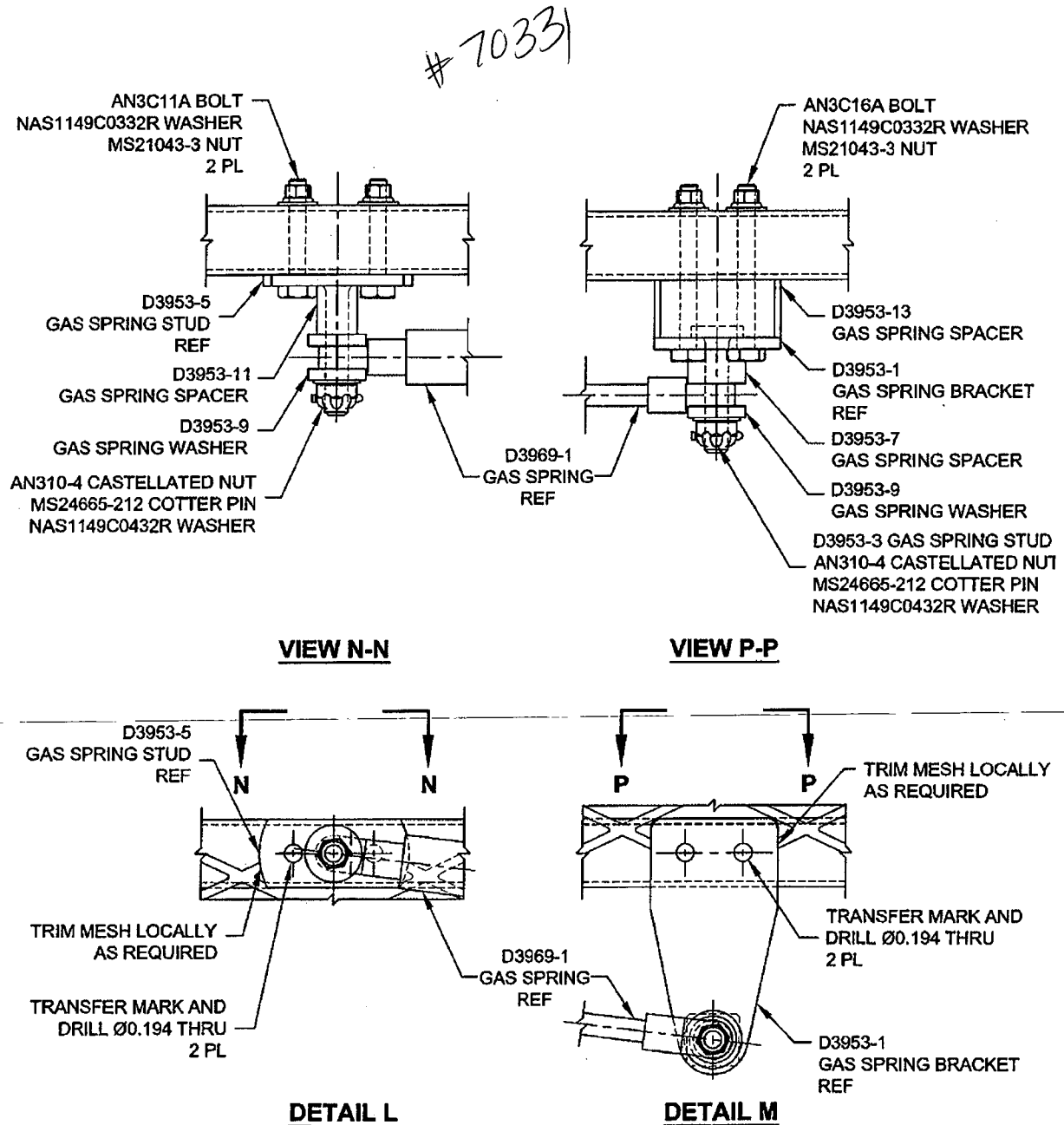


Figure 8b – Automatic Lid Opener Installation

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Revision: A

Date: 10.03.10